

Work Order ID 55685

January 27, 2010 11:34:46 AM

FAI



Item ID: D3954-1

Revision ID:

Item Name: GWT Pin

Start Date: 1/27/10 Start Qty: 1.00

Required Date: 1/29/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3954

B

100

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA824 & dwg D3954

FOLIO REV: N/A

DWG REV: B

2-Deburr as required

SL 10/01/29

20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/01/29

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

LB 10/01/29

135



SprayPaint

Spray Painting

powder
100%

Spray Painting per QSI005 4.2

0.00

M113544

Memo

0.00

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

2- SPRAY PAINT YELLOW AS PER DWG

A/R BATCH:

START 2:15pm 1/27/09 XW
Temp 320°F
FW 2:45pm

140



QC

Quality Control

QC14- Inspect Spray Paint

0.00

QC13

Memo

0.00

BR108229 (20)

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Page 3

Item ID: D3954-1

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Setup Start



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Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

162
HAY
SIN

Per 1/2/11 (2)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/11

W10-02-11

Picklist Print

January 27, 2010 11:34:45 AM

Page 1

Work Order ID: 55685

Parent Item: D3954-1

Parent Item Name: GWT Pin

Comments:

Start Date: 1/27/10

Required Date: 1/29/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	64.3700	0.2400			



303 Round Bar 1.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64.37

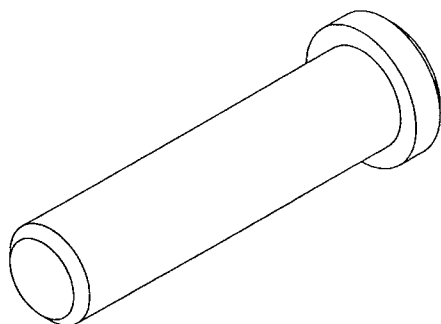
111571

2.37

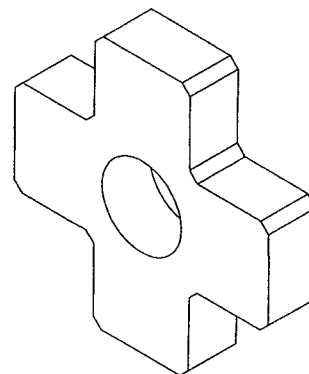
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62

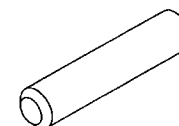
4.8 JL 10/01/29



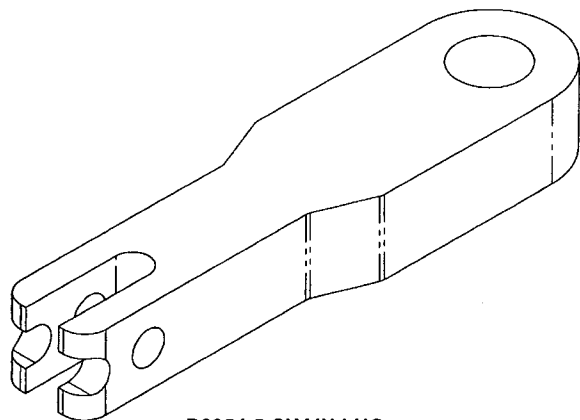
D3954-1 GWT PIN



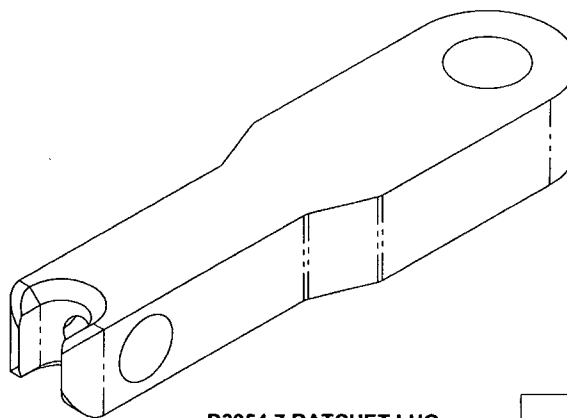
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



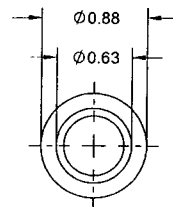
D3954-7 RATCHET LUG

RELEASED
2009-10-19

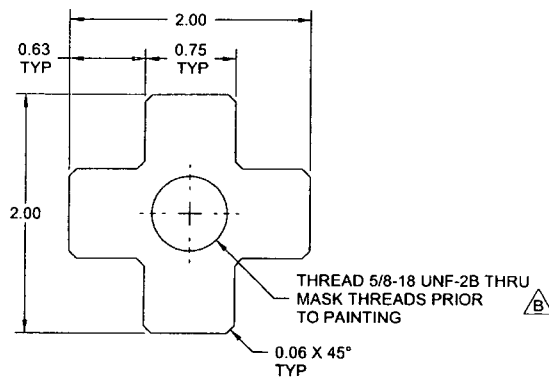
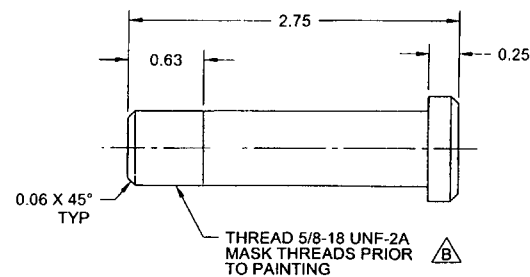
MP

55685

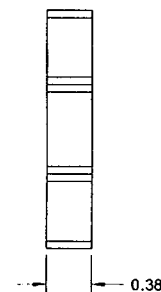
REV.	DESCRIPTION	BY	DATE
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED		D3954	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		MISC MACHINED PARTS GWT KIT	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.10.15		



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2009-10-19

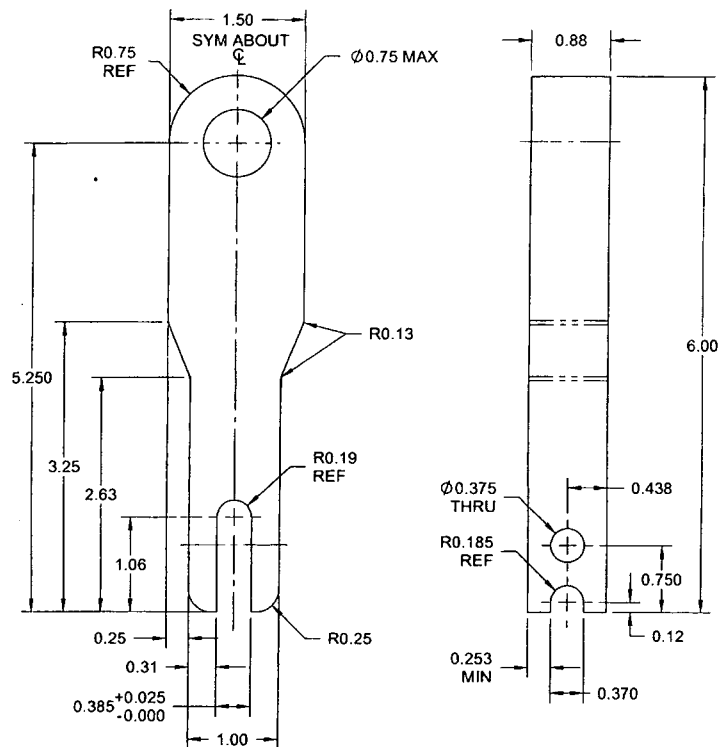
55685

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

634

635

637



D3954-5 CHAIN LUG

NOTES:

1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

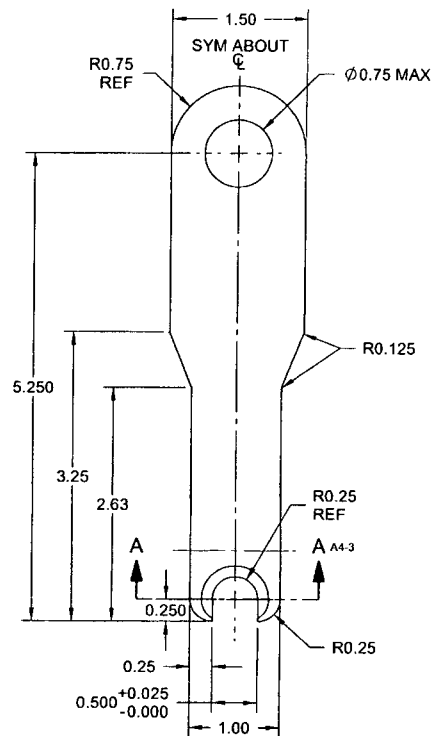
9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

ALTERNATE MATERIAL:

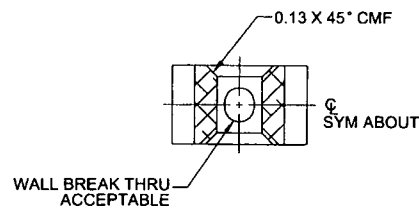
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

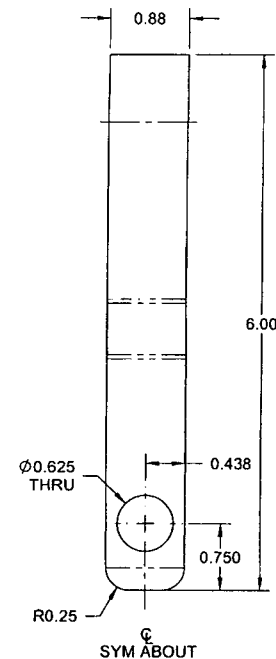
- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs



D3954-7 RATCHET LUG




SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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L Lacelle

From: Sian Willems [swillems@dartaero.com]

Sent: January 27, 2010 11:07 AM

To: 'L Lacelle'

Cc: 'Dan Stow'

Subject: pin for gross weight tow cable

Hi Linda,

Can we please get the following for the whale for HAI?

Qty. 1 D3954-1

Qty. 1 D3954-~~2~~ - 3

They'll have to be painted yellow. I have one each scrap that also need to get painted, I've given these to Gary and asked him to wait until he gets the others from you before painting yellow.

Thanks,

Sian Willems

Marketing

T - 1.613.632.5200

F - 1.613.632.1185

C - 1.613.676.0577

swillems@dartaero.com

DART aerospace Ltd.

1/27/10